

Work Order ID 77648

77648

Page 1

December-14-11 10:36:13 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long RH

Start Date: 14/12/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/12/14

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100 DOCUMENT CONTROL A 0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5/12/14

for MLJ 12-2-6
(10)

110 Large Fab 0.00

110

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

3-Grind End Plate flush

114514
119912

12.01.24

10

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop *NS2*

Start Date: 14/12/2011 **Start Qty:** 10.00

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

10X ϕ m.f. 12/01/30

180 Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod 114514

6-Grind End Plate flush

7-Install last rivet as per Dwg.

12.01.31

10 ϕ

Ac 12/02/01

x10

ϕ

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SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	Sizler						
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Sizler			+10			
						RH			
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	HL 1226.		

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220 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

220

Powdercoat

Powder Coating

Memo

START TIME: 1:00

OVEN TEMPERATURE: 320 °F

FINISH TIME: 1:30

0.00

230 Wing Walk as per dwg QSI005 4.4 Batch 150105 0.00

230

HandFinish

Hand Finishing

Memo

0.00

240 QC3- Inspect Part Finish 0.00

240

QC

Quality Control

Memo

0.00

10 X 2 M-L 12/02/07
RLT

10 HK 1227.

14/02/14 (u)

M11 0480

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							SP 12-02-07
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							(HIO) HIT
Quality Control									
270		0.00							
270									
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: _____								

HALL

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/2/14

ME
12-02-14

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D:
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1 Step		Manufactured	No			110	Each	0.0000	1	10			
D3272-1						B 77651 = (10)			**			12.01.03 (10)	

D3067-1 End Plate		Manufactured	No			110	Each	87.0000	1	10			
D3067-1									**			12.01.24	

Location	Loc Qty	Loc Code
WA016 B78022	87	
67582	2	
68214	1	
76179	84	

D3219-1 Plate		Manufactured	No			110	Each	66.0000	2	20			
D3219-1									**			12.01.24	

Location	Loc Qty	Loc Code
WA016 B77674	66	
73410	12	
76226	54	

D3066-1 Spacer		Manufactured	No			180	Each	106.0000	2	20			
D3066-1									**			12.01.31	

Location	Loc Qty	Loc Code
WA015 B78022	106	
75076	6	
76180	100	
B77564	1	

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D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

3,026.000

16

160

MS20600-AD4W4

Rivets

**

12.01.31

Location

Loc Qty

Loc Code

ST321 120308 3021

116188 59

117364 253

117601 200

117885 195

118840 1089

119860 225

119883 1000

WA018 5

116712 5

160

D3065-041

Manufactured

No

180

Each

12.0000

1

10

D3065-041

Step Leg Assembly Hi

**

12.01.31

Location

Loc Qty

Loc Code

WA013 378497 12

76193 12

10

D3067-1

Manufactured

No

180

Each

87.0000

1

10

D3067-1

End Plate

**

12.01.31

Location

Loc Qty

Loc Code

WA016 378022 87

67582 2

68214 1

76179 84

10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

AN3-35A Purchased No 250 Each 103.0000 2 20
AN3-35A ** *m/20187 SP*
 Bolt

Location	Loc Qty	Loc Code
ST353	103	
119449	100	
119641	3	

D3235-1 Manufactured No 250 Each 107.0000 2 20
D3235-1 ** *B77566 20X SP*
 Mounting Lug

Location	Loc Qty	Loc Code
ST481	107	
73411	7	
75547	100	

D3278-041 Manufactured No 250 Each 42.0000 1 10
D3278-041 ** *B 77057 10X SP*
 Support Assembly

Location	Loc Qty	Loc Code
ST481	42	
76169	35	
76170	7	

AN960JD416 NAS1149D0463J Purchased No 250 Each 0.0000 16 160
AN960.ID416 ** *m/19075 SP*
 Washer

AN960JD516 NAS1149D0563J Purchased No 250 Each 0.0000 4 40
AN960.ID516 ** *m/18206 SP*
 Washer
12-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 14/12/2011

Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

105.0000

2

20

AN5-36A

Bolt

**

M/20423 SP.

Location

Loc Qty

Loc Code

ST340

105

119449

30

119641

75

D2618

Manufactured

No

250

Each

112.0000

2

20

D2618

Bushing

**

B77563 SP.

Location

Loc Qty

Loc Code

ST019

112

74458

12

76130

100

D2230-3

Manufactured

No

250

Each

217.0000

4

40

D2230-3

Lug

**

B77561 → 31X.

Location

Loc Qty

Loc Code

ST480

217

53881

4

70973

1

75546

14

76642

198

SP 12-02-08

B78593 9X

77648 X 10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 15/02/2012

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

205.2445 1.2 12

D2856-400

Abraison Strip

**

SP

Location

Loc Qty

Loc Code

ST409

205.2445

63735

0.6696

68076

0.3149

71164

21.66

73491

182.6

12x

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

7,032.000 2 20

MS21042L3

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

7032

117441

16

117885

32

118451

5

118927

3

119017

5994

119075

982

20x

AN4-13A

Purchased No

250 Each

746.0000 8 80

AN4-13A

Bolt

**

11/20/87
SP 12-02-07

Location

Loc Qty

Loc Code

ST357

746

118078

17

118838

129

119449

500

119798

100

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Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

2,142.000

2

20

MS21042I 5

**

SP

Nut

Location

Loc Qty

Loc Code

ST300

2142

116105

5

116548

43

117611

52

118179

496

118910

46

119109

1500

20x

MS21042L4

Purchased

No

250

Each

9,264.000

8

80

MS21042I 4

**

SP

Nut

Location

Loc Qty

Loc Code

ST300

9264

117441

51

117601

342

118451

133

119017

3738

119075

5000

80x

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40

AN960.ID10

**

m120142 SP
12-02-07

Washer

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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SUBJECT TO AMENDMENT
WITH NOTICE
ORDER
77648 MJS
11/12/14

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

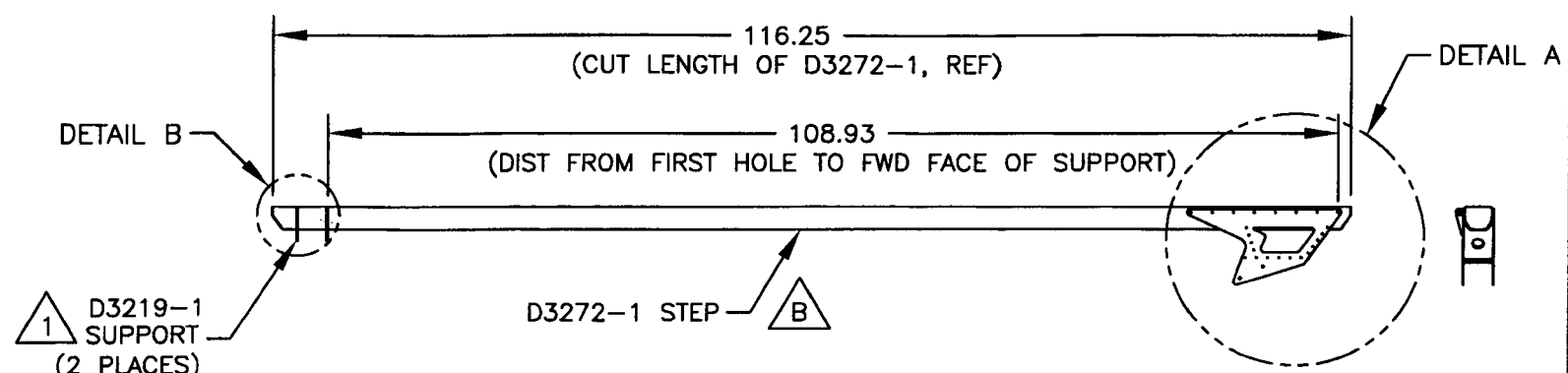
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

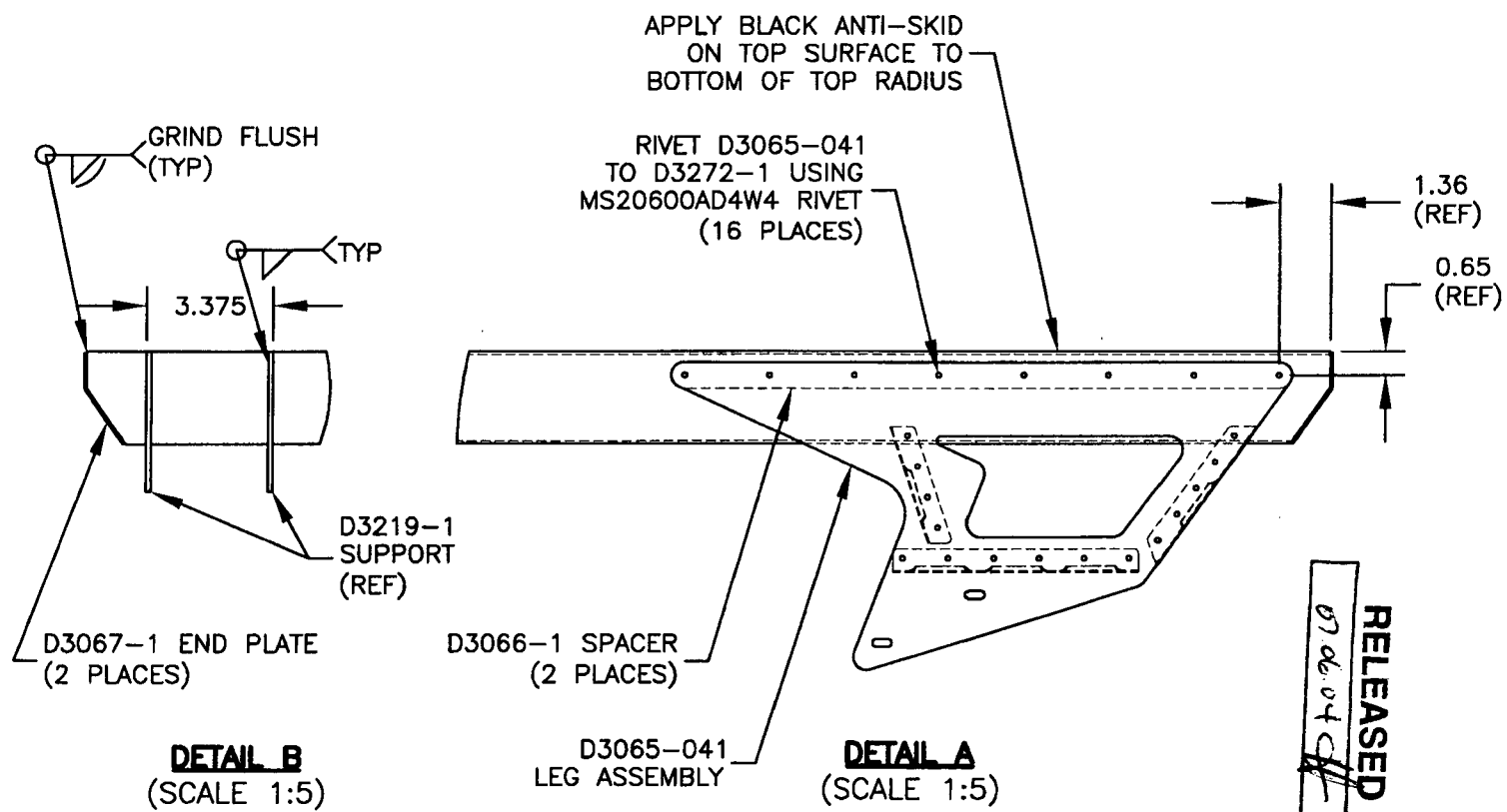


DESIGN	99	DRAWN BY	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED	CE	APPROVED	JB	DRAWING NO. D3272	SHEET 2 OF 3
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20

77648



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

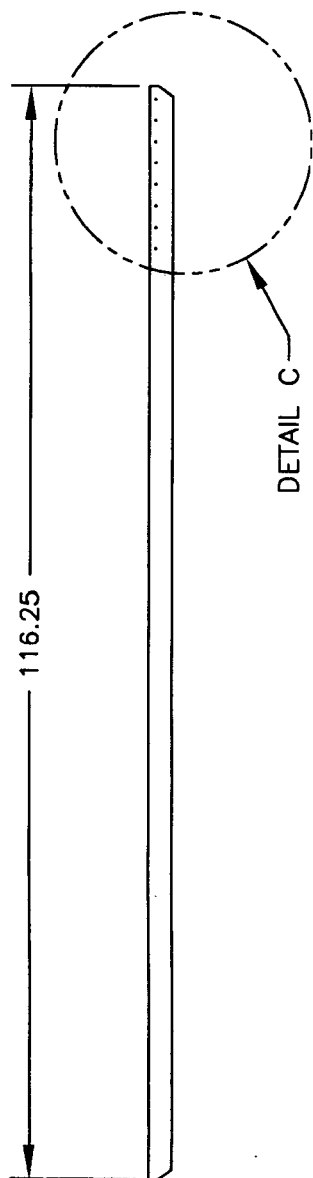
NOTE: Date & initial all entries



DESIGN 9P	DRAWN BY JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

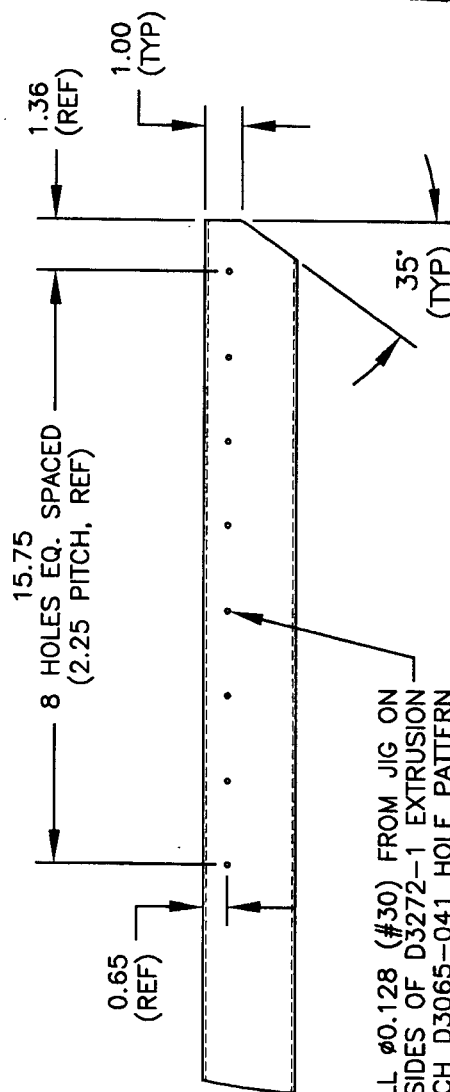
07.06.04



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.